

Work Order ID 68947

Tuesday, April 26, 2011 10:42:00 AM



Page 1

Item ID: D3500-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle

Start Date: 4/26/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 5/24/2011 Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan:

Date: 11-04-26 Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
100	HAAS CNC VERTICAL MACHINING #1	0.00							
	HAAS 1								
HAAS CNC vertical machine #1	<p>Memo</p> <p>Program Batch No 68947 Double check by: <i>JK</i> <input type="checkbox"/> 1-Machine Step No 1 per Folio FA641 and inspect per attached Dimension Sheets <input type="checkbox"/> 2-Machine Step No 2 per Folio FA641 and inspect per attached Dimension Sheets <input type="checkbox"/> 3-Machine Step No 3 per Folio FA641 and inspect p</p>	0.00							
						12	0		
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
	QC								
Quality Control	Memo	0.00							
						12	0		
120	QC8- Inspect parts - second check	0.00							
	QC								
Quality Control	Memo	0.00							
						12	0		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries.

Work Order ID 68947

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Page 2

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Start Date: 4/26/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 5/24/2011 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



HandFinish

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

Hand Finishing

12 BL 11-9-26

140



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

Memo

0.00

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

3:15

320°F

150



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

12 x DM-f u/oul 27

4/27 12

M118434

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

Work Order ID 68947

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Page 3

Item ID: D3500-1

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Revision ID:

Stop



Item Name: Saddle

Start Date: 4/26/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 5/24/2011 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160



Packaging

Identify as per dwg & Stock Location: ST424

0.00

(12x)

SP 11-09-28

Memo

0.00

12

BR 11-9-28

Packaging

170



QC

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

Quality Control

n/a/28
MF 11-04-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, April 26, 2011 10:42:06 AM

Page 1

Work Order ID: 68947



Parent Item: D3500-1

Parent Item Name: Saddle

Start Date: 4/26/2011

Required Date: 5/24/2011

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A New Issue 06-06-15 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6102-013 Saddle Billet		Manufactured	No			100	Each	12.0000	1	12		SL 11-09-24	

Location

MAT043

59467

60713

61300

70674

Loc Qty

12

30

80

10

Loc Code

12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 68947
Description: Saddle		Part Number: D3500-1
Inspection Dwg: D3500	Rev: C	Page 1 of 1

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By 5	Date 6
A	0.483	0.490		.485	.485	.485	.485	.485	.486
B	1.175	1.185		1.180	1.180	1.180	1.180	1.180	1.180
C	3.145	3.155		3.150	3.150	3.150	3.150	3.150	3.150
D	1.175	1.185		1.180	1.180	1.180	1.180	1.180	1.180
E	0.365	0.385		.376	.376	.376	.376	.376	.376
F	0.490	0.510		.499	.500	.501	.500	.500	.500
H									
(Note: Dimension I is 0.015" over flange)									
I	R1.575	R1.595		1.588	1.588	1.587	1.588	1.588	1.588
J	0.240	0.260		.245	.245	.246	.245	.246	.246
K	0.490	0.510		.500	.500	.500	.500	.500	.500
L	3.590	3.650		3.625	3.625	3.625	3.625	3.625	3.625
M	0.315	0.322		.316	.316	.316	.316	.316	.316
N	0.256	0.262		.257	.257	.257	.257	.257	.258
O	6.500	6.520		6.510	6.510	6.510	6.510	6.510	6.510
P	5.990	6.010		6.000	6.000	6.000	6.000	6.000	6.000
Q	2.820	2.830		2.825	2.825	2.825	2.825	2.825	2.825
R	2.495	2.505		2.500	2.500	2.500	2.500	2.500	2.500
S	2.245	2.255		2.250	2.250	2.250	2.250	2.250	2.250
T	1.120	1.130		1.125	1.125	1.125	1.125	1.125	1.125
U	0.540	0.560		.548	.548	.549	.549	.550	.550
V	0.793	0.803		.798	.798	.798	.798	.798	.798
W	R.240	R.260		.250	.250	.250	.250	.250	.250
X	0.040	0.060		.050	.050	.050	.050	.050	.050
Y	0.100	0.120		.110	.110	.110	.110	.110	.110
AA	R1.125	R1.145		1.134	1.136	1.135	1.136	1.136	1.134
AB	R.490	R.510		.500	.500	.500	.500	.500	.500
AC	0.615	0.635		.635	.635	.635	.635	.635	.635
AD	0.240	0.260		.254	.253	.253	.253	.253	.254
AE	1.810	1.830		1.821	1.819	1.820	1.820	1.820	1.820
AF	0.240	0.260		.250	.251	.250	.251	.251	.249
AG	0.140	0.160		.150	.150	.150	.150	.150	.150
AH	0.140	0.160		.152	.154	.153	.153	.153	.152
AI	0.140	0.160		.155	.154	.152	.152	.153	.147
Accept/Reject									

Measured by: <i>[Signature]</i>
Date: 11-09-23 / 11/09/26

Audited by: <i>[Signature]</i>
Date: 11.9.25

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	<i>[Signature]</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	
Description: Saddle		Part Number: D3500-1	
Inspection Dwg: D3500		Rev: C	
		Page 1 of 1	

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	17	18	19	110	111	Date/2
A	0.483	0.490		.486	.486	.486	.486	.486	.486
B	1.175	1.185		1.180	1.180	1.180	1.180	1.180	1.180
C	3.145	3.155		3.150	3.150	3.150	3.150	3.150	3.150
D	1.175	1.185		1.180	1.180	1.180	1.180	1.180	1.180
E	0.365	0.385		.377	.380	.380	.377	.377	.377
F	0.490	0.510		.500	.500	.500	.500	.500	.500
H									
(Note: Dimension I is 0.015" over flange)									
I	R1.575	R1.595		1.590	1.591	1.589	1.592	1.593	1.593
J	0.240	0.260		.246	.246	.246	.245	.245	.245
K	0.490	0.510		.500	.500	.500	.500	.500	.500
L	3.590	3.650		3.625	3.625	3.625	3.625	3.625	3.625
M	0.315	0.322		.317	.317	.316	.316	.316	.316
N	0.256	0.262		.258	.258	.258	.258	.258	.258
O	6.500	6.520		6.510	6.510	6.510	6.510	6.510	6.510
P	5.990	6.010		6.000	6.000	6.000	6.000	6.000	6.000
Q	2.820	2.830		2.825	2.825	2.825	2.825	2.825	2.825
R	2.495	2.505		2.500	2.500	2.500	2.500	2.500	2.500
S	2.245	2.255		2.250	2.250	2.250	2.250	2.250	2.250
T	1.120	1.130		1.125	1.125	1.125	1.125	1.125	1.125
U	0.540	0.560		.548	.550	.550	.550	.550	.550
V	0.793	0.803		.798	.798	.798	.798	.798	.798
W	R.240	R.260		.250	R.250	.250	.250	.250	.250
X	0.040	0.060		.050	.050	.050	.052	.053	.053
Y	0.100	0.120		.110	.110	.110	.110	.110	.111
AA	R1.125	R1.145		1.133	1.133	1.134	1.134	1.136	1.136
AB	R.490	R.510		.500	R.500	.500	.500	.500	.500
AC	0.615	0.635		.635	.635	.635	.635	.635	.635
AD	0.240	0.260		.255	.255	.255	.255	.255	.254
AE	1.810	1.830		1.820	1.820	1.820	1.822	1.821	1.821
AF	0.240	0.260		.257	.250	.257	.254	.254	.254
AG	0.140	0.160		.152	.152	.155	.155	.155	.155
AH	0.140	0.160		.157	.157	.150	.150	.151	.157
AI	0.140	0.160		.152	.152	.150	.149	.149	.150
Accept/Reject									

Measured by:	CMK
Date:	11/09/26

Audited by:	29
Date:	11.9.26

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	AA

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY

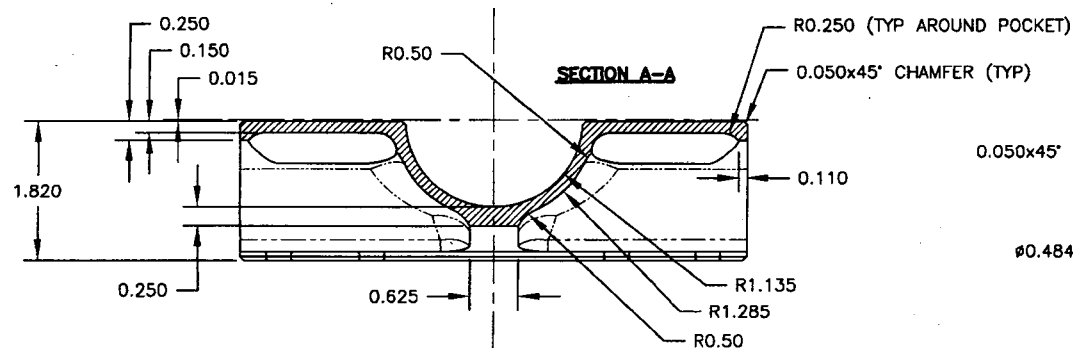
SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER

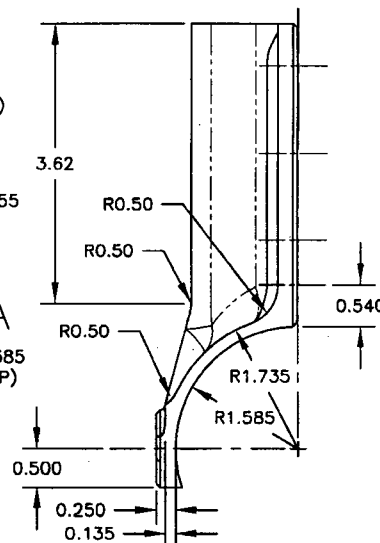
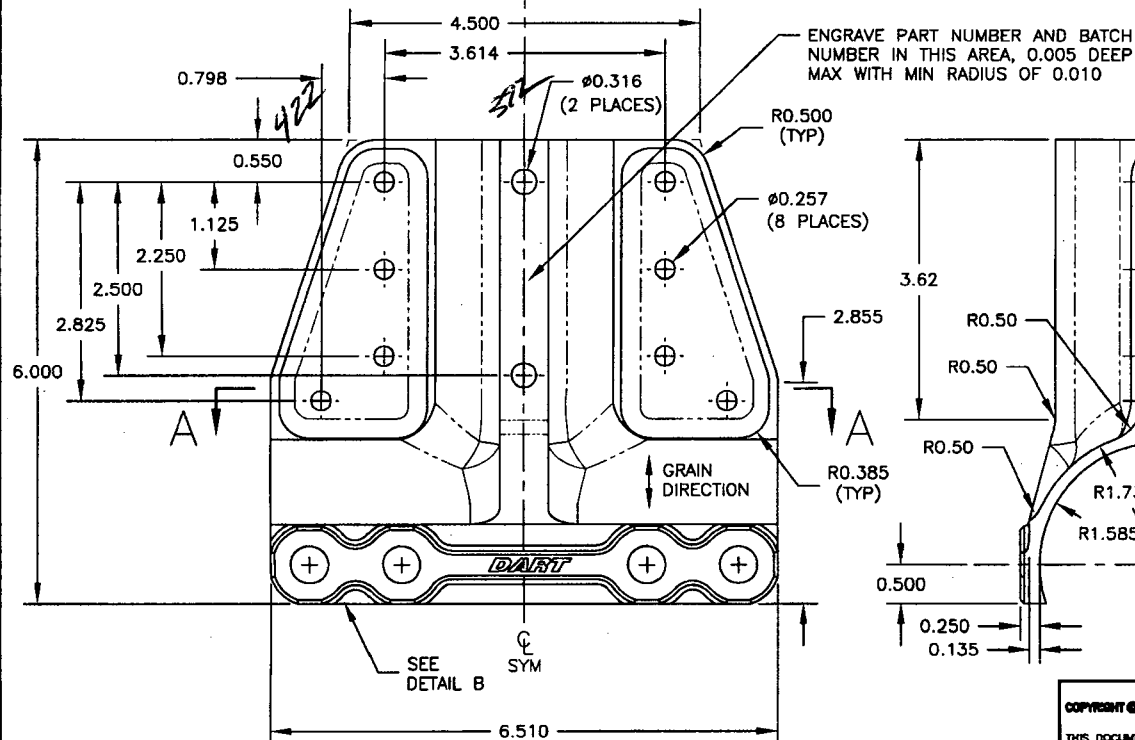
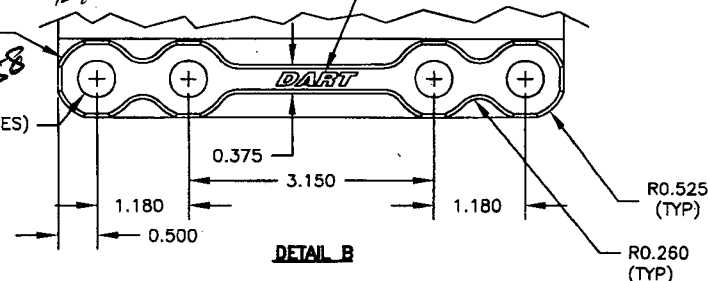
NO. *68947*

PH110926

ENGRAVE DART LOGO IN
THIS AREA TO A MAX
DEPTH OF 0.015 AND A MIN.
TOOL RADIUS OF 0.250



0.050x45° CHAMFER
(TYP)
258
Ø0.484 (4 PLACES)



D3500-1 SADDLE

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/B OR QQ-A-250/11)
(MAKE FROM D6102-013 SADDLE BILLET, 6061)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1,
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER
DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

RELEASED

06.08.15

C	06.06.30	MAT'L NOW 6061-T6/T651
B	06.05.29	CHANGE DIMS; MAT'L NOW 7075-T7351
A	06.04.18	NEW ISSUE
DESIGN	<i>GP</i>	DRAWN BY <i>PH</i>
CHECKED	<i>#</i>	APPROVED <i>#</i>
DATE	06.06.30	TITLE SADDLE
DRAWING NO. D3500		REV. C
DART AEROSPACE LTD. WINDSOR, ONTARIO, CANADA		SHEET 1 OF 1
SCALE		2:3

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PERSON WITHOUT WRITTEN PERMISSION FROM
DART AEROSPACE LTD.

W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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